

Date:  
User:Monday, 8/21/2006 2:11:18 PM  
Kim Johnston

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 28251  
**Estimate Number** : 10512  
**P.O. Number** : N/A  
**This Issue** : 8/21/2006 **S.O. No.** : N/A  
**Prsht Rev.** : NC  
**First Issue** : N/A **Type** : MACHINED PARTS  
**Previous Run** : 27362  
**Written By** : \_\_\_\_\_  
**Checked & Approved By** : KG 06.08.21  
**Comment** : Est: A 02.04.15 New Issue NG  
 Est: B 05.12.12 added deburr EC

**Drawing Name** : PLUG  
**Part Number** : D26511  
**Drawing Number** : D2651 REV. B  
**Project Number** : N/A  
**Drawing Revision** : B  
**Material** : N/A  
**Due Date** : 9/5/2006 **Qty:** 300 **Um:** Each

## Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 M6061T6R0500 6061-T6 Round Bar .500"



**Comment:** Qty.: 0.0421 f(s)/Unit Total : 12.6315 f(s)  
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia  
 (M6061T6R0500)  
 Batch: m 101421

2.0 HARDINGE HARDINGE CNC LATHE SMALL

PG



Issue P.O. 2057 C20609106



**Comment:** HAAS CNC VERTICAL MACHINING #1 turn per draw D2651 Rev B  
 1- Turn as per Folio FA219 and Dwg D2651  
 2- Deburr

3.0 Q02 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive + Inspect for



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

transit damage Puck/15 303

4.0 Q05 SECOND CHECK



**Comment:** SECOND CHECK

Inspect level 5

08.09.18

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr - as per dwg D2651

N/A C206109118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/11/06

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28251

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a.m*

*06-10-03*

*300*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

*FC 06 10 24 (300)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*a.m*

*06/01/06*

*300*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP15*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/11/06*

Job Completion



*U 06/01/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

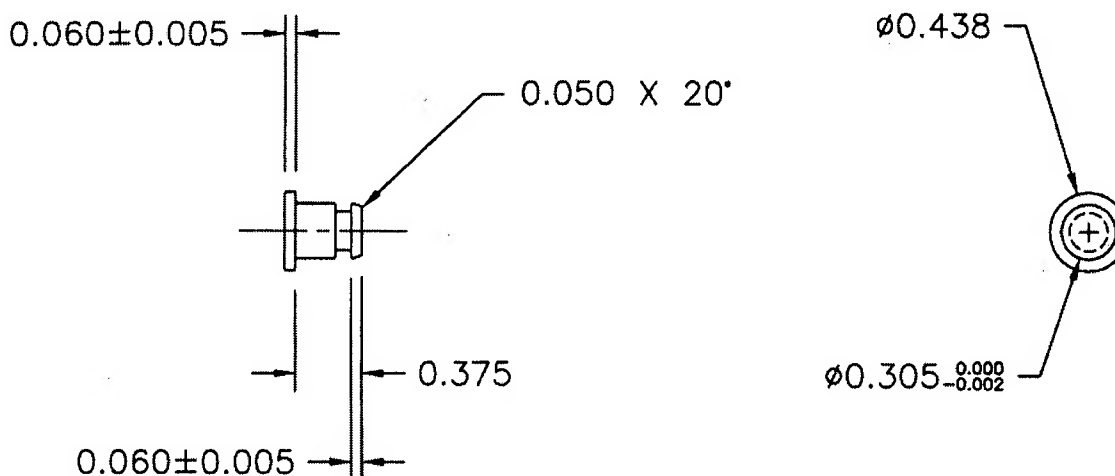


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

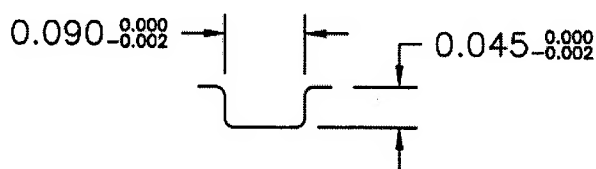
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28251

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Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

*Handwritten signature and date: 06/11/06*

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

300

D 2651-1

Plug

2057

MATERIAL: supplied by DART M101421

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Denise Robinson

*Handwritten signature of Denise Robinson*

Vankleek Hill, September 13, 2006

